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RB KIT 407M-25
Job Sheet 200559



Part No: RB KIT 407M-25 Job Qty: 12 pcs

Part Name: Gauge Pin .1728" dia.



Part Weight: 0 lbs Status: New Priority: Medium
Job Created: 9/12/19 Job Tracking No:
Due Date: 10/7/19 Created By: Chantal Lavoie
Type: SOLD Description:

Note: DWG RB KIT 407M REV.D IPP REV A 18.01.29 NEW ISSUE RQ VERIFIED BY DP/IPP Rev B 18.03.08 DWG update Rev. C DP Verify DD/IPP Rev. C 19.01.24 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
90	Purchasing	12 pcs		10/7/19	0.00	0.00	Purchasing - 1	
							Purchasing - 2	
							Purchasing - 3	
95	Packaging 2-1 - Receive - B4B	12 pcs		10/7/19	0.00	0.00	Packaging 2 - 1 - B4B	
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	

N/A

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100 QC 6	12 pcs	10/7/19	0.00 0.00	Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				QC 6 - 9	
110 Small Fab - 2 - B4B	12 pcs	10/7/19	0.00 1.50	QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	
				QC 6 - 81	
				Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
120 QC 5	12 pcs	10/7/19	0.00 0.00	Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
130 Packaging 3-1 - Stock - B4B	12 pcs	10/7/19	0.00 0.00	QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	

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[Dart Hawkesbury] Job Sheet - Lavoie, Chantal

				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	12 pcs	10/7/19	0.00 0.00	QC 21 - SA - 21	21
				QC 21 - SA - 70	70
				QC 21 - SA - 53	53

Part Op 90 - (Purchasing)

Descriptions: 95 - (Receive & Inspect for Damage & Mat'l Carts)

100 - (QC8- All purchased or subcontracted products)

110 - 1-Cut pin in half, 2-Deburr 3-Put pin in small sealable plastic bag with a small amount of LPS 2 to prevent corrosion.

4-Package as per note 10.

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location:)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
21135A54	Plug Gauge	6 Ea (.5 ea)	90-Purchasing	220911

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Purchasing	21135A54	6	71	0

Part Specifications				
Specifications could not be found.				

Flex 9/12/19 12:01 PM Dart.Lavoie.Chantal

Ø A +0.0000
-0.0004
(PER TABLE 1)



TABLE 1 GAUGE PIN DIMENSIONS			
PART NUMBER	Ø A	B	PURCHASE PART NUMBER (McMASTER CARR)
RB KIT 407M-01	Ø.02400	1.00"	21135A62 OR EQUIV.
RB KIT 407M-03	Ø.04000	1.00"	21135A63 OR EQUIV.
RB KIT 407M-05	Ø.05600	1.00"	21135A63 OR EQUIV.
RB KIT 407M-07	Ø.06000	1.00"	21135A63 OR EQUIV.
RB KIT 407M-09	Ø.06000	1.00"	21135A63 OR EQUIV.
RB KIT 407M-11	Ø.06000	1.00"	21135A64 OR EQUIV.
RB KIT 407M-13	Ø.10800	1.00"	21135A64 OR EQUIV.
RB KIT 407M-15	Ø.12000	1.00"	21135A64 OR EQUIV.
RB KIT 407M-17	Ø.14400	1.00"	21135A64 OR EQUIV.
RB KIT 407M-19	Ø.14400	0.25"	21135A64 OR EQUIV.
RB KIT 407M-21	Ø.16000	1.00"	21135A64 OR EQUIV.
RB KIT 407M-23	Ø.16000	0.25"	21135A64 OR EQUIV.
RB KIT 407M-25	Ø.17200	1.00"	21135A64 OR EQUIV.
RB KIT 407M-27	Ø.17200	0.25"	21135A64 OR EQUIV.
RB KIT 407M-29	Ø.18000	1.00"	21135A64 OR EQUIV.
RB KIT 407M-31	Ø.19200	1.00"	21135A65 OR EQUIV.

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 20020

RB KIT 407M-01 THRU -31 Ø.0005 CLASS X PLUG NO-GO GAUGE

NOTES:
1) MATERIAL: SEE TABLE 1 FOR MATERIAL SPECIFICATION
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: XX.X = $\pm 0.1"$ / $\pm 0.1"$
X.XX = $\pm 0.01"$ / $\pm 0.05"$
X.XXX = $\pm 0.005"$ / $\pm 0.1"$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A

DESIGN DRAWN	DESIGN CHECKED	DESIGN INFO. APPROV.	DESIGN APPROVED	DATE 1/17/2019
DART AEROSPACE LTD 1000 BAYVIEW AVE., SUITE 100 SCARBOROUGH, ONTARIO, CANADA				
TOTAL PART # RB KIT 407M				
TITLE SPLINE MEASURING KIT				
REV. D SHEET 3 OF 3 SCALE NTS				